

Date: Thursday, 16/10/2008 10:46:23 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: 412 GROSS WEIGHT TOWING KIT		
Job Number	: 42642			Part Number	: D412666011		
Estimate Number	: 12592			Drawing Number	: D412-666 REV C		
P.O. Number	:			Project Number	: N/A		
This Issue	: 16/10/2008 S.O. No. :			Drawing Revision	: C		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : MACHINED PARTS			Due Date	: 04/11/2008 Qty: 4 Um: Each		
Previous Run	: 40719						
Written By	:						
Checked & Approved By	: <u>JUD 08.10.16</u>						
Comment	: Est Rev:B Added GHG 002 NG 02-03-06						
	Est Rev:C As per Rev C JLM 07-09-07 Verified By:EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	
			<u>S 08/10/28</u>
		Comment: Photocopy bluefile & type labels per PPP412-666-011 CHG 004	
2.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1	
		Pick Packing Kit	
3.0	D2888	Lug B42714 5X Batch: 37167x1 B46733x2	
			<u>AS 08/10/21 (X)</u>
		Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)	
4.0	AN615A	Bolt	
		Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)	
5.0	AN645A	Bolt	
		Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)	
		Bolt Batch: M168744	<u>AS 08/10/21 (X)</u>
		Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)	
		Bolt Batch: M167378	<u>AS 08/10/21 (X)</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 16/10/2008 10:46:23 AM

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 412 GROSS WEIGHT TOWING KIT

Job Number: 42642

Part Number: D412666011

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 AN960JD616

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Washer

Batch:

M108521

DS 08/10/21 (x4)

7.0 MS21042L6

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Nut

Batch:

M108183

DS 08/10/21 (x4)

8.0 QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-666-011

Location: 311X

PPP Rev: E

S10b6

SP

10.0 QC21

FINAL INSPECTION/W/O RELEASE



4

Comment: FINAL INSPECTION/W/O RELEASE

A 08/10/29

Job Completion



U 08/10/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

1.0 APPLICABILITY:

GROSS WEIGHT TOWING KIT D412-666-011 MAY BE INSTALLED ON DART D205-634-XXX OR D204-635-XXX OR D412-742-XXX SKIDTUBES INSTALLED ON 412 AIRCRAFT TO ALLOW GROUND HANDLING AT GROSS WEIGHT IN ACCORDANCE WITH BELL SERVICE INSTRUCTION BHT-412-SI-58. IT IS ALSO ACCEPTABLE TO INSTALL THIS KIT ON 204/205/210/212 AIRCRAFT EQUIPPED WITH DART SKIDTUBES IN ORDER TO PRESERVE THE LIFE OF THE AFT CROSSTUBES. THIS KIT CONTAINS ENOUGH PARTS TO INSTALL D2888 LUGS ON BOTH SKIDTUBES.

2.0 PARTS LIST:

QTY -011	PART	DESCRIPTION
X	D412-666-011	GROSS WEIGHT TOWING KIT
2	D2888	LUG
4	AN6-15A	BOLT
4	AN6-45A	BOLT
8	AN960JD616	WASHER
4	MS21042L6	NUT (or MS21042-6)

3.0 WEIGHT AND BALANCE:

INSTALLATION	WEIGHT	LONGITUDINAL	
		ARM	MOMENT
D412-666-011	1.90 lb 0.86 kg	163.0 in 4.14 m	310 in lb 3.56 m kg

4.0 PROCEDURE:

- 1) REMOVE AN6-12A BOLTS (4) ON INBOARD SIDE OF AFT SADDLE AND DISCARD. ON LANDING GEAR WITH DART AFT CROSSTUBES, REMOVE (4) AN6-40A BOLTS.
- 2) INSTALL D2888 LUGS WITH AN6-15A BOLTS (2) AS SHOWN IN FIGURE 1. USE AN6-45A (2) BOLTS ON DART CROSSTUBES, AS SHOWN IN FIGURE 2.
- 3) TORQUE BOLTS TO 95-110 in-lb (10.7-12.4 N·m).

5.0 NOTE:

IT IS ACCEPTABLE TO REPLACE THE AN6-15A/45A BOLTS WITH LONGER OR SHORTER AN6 BOLTS AS REQUIRED AND/OR INSTALL EXTRA AN960JD616 WASHERS UNDER NUT TO ENSURE 1.5 TO 4 THREADS IN SAFETY.

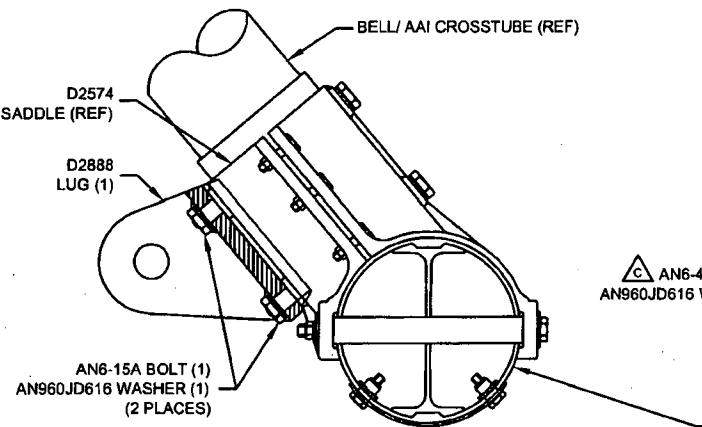


FIGURE 1
(BELL/AAI CROSSTUBES)

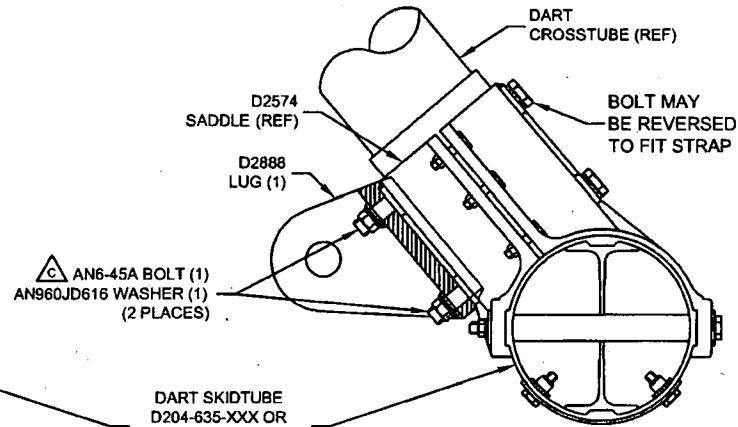


FIGURE 2
(DART CROSSTUBES)

C	- AN6-45A WAS AN6-43A, ADD NOTES - TO ENSURE COMPATIBILITY WITH D412-742-011/-013 - ESTIMATE (PARTS/PICK LIST) IS AFFECTED	MB	07.08.09
B	UPDATE KIT FOR BOTH SKIDTUBES AND COMPATIBILITY WITH DART CROSSTUBES	CP	02.03.04
A	NEW ISSUE	CP	99.05.03
REV.	DESCRIPTION		
DESIGN	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	<i>1</i>		
CHECKED	<i>PH</i>		
MFG. APPR.	DRAWING NO. D412-666 REV. C SHEET 1 OF 1		
APPROVED	<i>#</i>		
DE APPR.	<i>#</i>		
DATE	TITLE 412 GROSS WEIGHT TOWING KIT SCALE 1:4		
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